

Work Order ID 52904

October 19, 2009 12:37:13 PM

Page 1

Item ID: D3283-1

Accept

Revision ID: E

Item Name: Doubler

Setup Start

Stop

Start Date: 10/19/09 Start Qty: 20.00

Required Date: 11/02/09 Req'd Qty: 20.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: *PL*

Date: *09-10-09*

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3283

Rev E

100

0.00

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3283 ☐ Dwg Rev: E ☐ Prog Rev: E ☐ 2-
Debur if necessary

10 9-10-08

110

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

10 9-10-08

120

QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

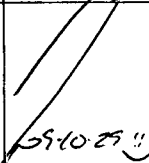
⇒ 8 631.128

ccanto
(421)

took
Qty1
for
Temp/see
8

W/O: 52904

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
01/10/22	#120	Took qty x1 for inspection Timeline.	S	01/10/22	(81)		S 01/10/22

Part No: D3283-1 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 52904

October 19, 2009 12:37:13 PM

Page 2

Item ID: D3283-1

Accept

Revision ID: E

Item Name: Doubler

Start Date: 10/19/09 Start Qty: 20.00

Required Date: 11/02/09 Req'd Qty: 20.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

Small Fab

Small Fab

Memo
Debur

0.00

0.00

21

11/9/10/28

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

*****ensure rivet fits in #30 (0.128") holes as per dwg *****

0.00

0.00

27 8 or 10/28

count

(+2) - 0

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

21

11/9/10/28

Work Order ID 52904



Page 3

October 19, 2009 12:37:13 PM

Item ID: D3283-1

Accept



Setup Start



Revision ID: E

Stop



Item Name: Doubler

Start Date: 10/19/09 Start Qty: 20.00



Cust Item ID:

Required Date: 11/02/09 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

160 QC3- Inspect Part Finish 0.00



QC

Quality Control

Memo

9-10-28

0.00

21

170 Identify as per dwg & Stock Location: _____ 0.00



Packaging

Packaging

Memo

0.00

21

9/10/28

180 QC21- Final Inspection - Work Order Release 0.00



QC

Quality Control

Memo

0.00

09/10/29

MF

09-10-28

Picklist Print

October 19, 2009 12:37:17 PM

Page 1

Work Order ID: 52904

Parent Item: D3283-1RevE

Parent Item Name: Doubler


Comments:

Start Date: 10/19/09

Required Date: 11/02/09

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased	No			100	sf	33.2841	4.9705	5.5		
												
6061-T6 .063 Sheet												

139-10-28

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

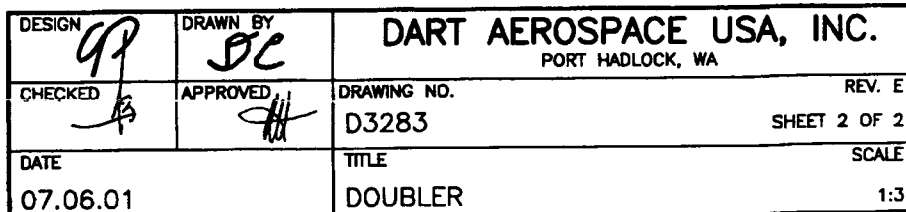
33.28412105

110551

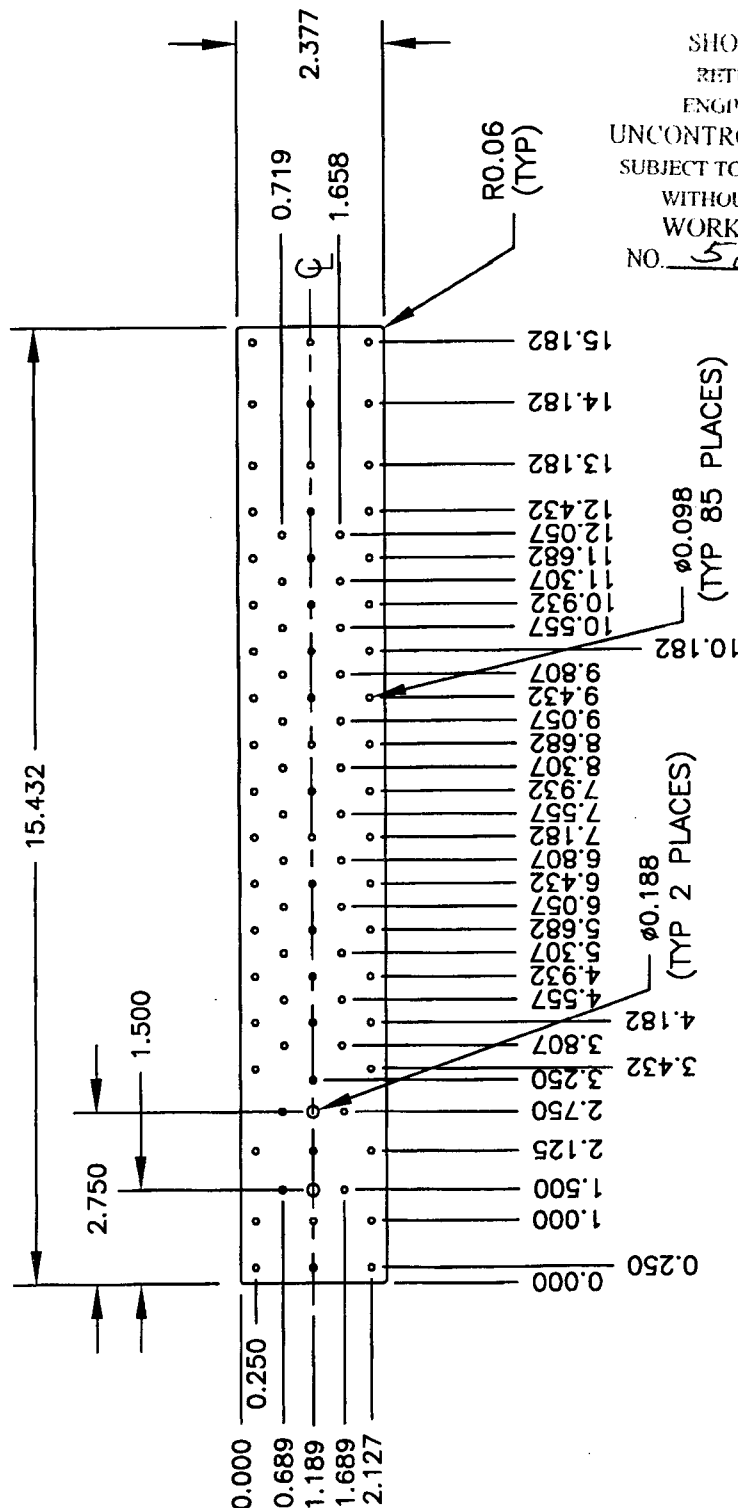
33.2841211

112939

112939



RELEASED
07-08-27 PM
PER ECN 959



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 52909

03283-3 DOUBLER

- 1) MATERIAL: 6061-T6, 0.080 THICK (QQ-A-250/11, REF DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

Copyright © 2004 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.